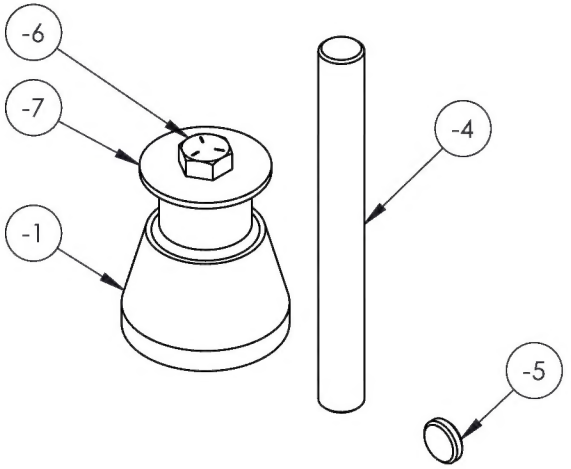
REVISIONS

| REV | ECR | DESCRIPTION | DATE | INITIAL | APPROVED |
|---|---|---|---|---|---|
| 1 | | CORRECTED AND COMPLETED FILE. IMPLEMENTED NEW TITLEBLOCK, BOM, & REVISION TABLE. ALSO DELETED OBSOLETE -2 & -3 TOOLS, RBT18531 IS THIER REPLACEMENT SOLD SEPARATELY. | 3/5/2008 | WP | DW |
| 2 | 16-0278 | UPDATED TO NEW DRAFTING STANDARD. **-1**, **-4**, **-5** CH'D MATERIAL WAS 4140 IS 4140/4142, ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D, DELETED WORK INSTRUCTIONS. **-1** CH'D DIM WAS R.080 IS R.08, WAS .060 X 45° IS .06 X 45°, WAS 5/16-24 UNF DEPTH .625 IS 5/16 -24 UNF -2B ↧ .62, CH'D ENGRAVE NOT WAS ENGRAVE P/N IS ENGRAVE T/N, S/N, "MADE IN USA". **-4** CH'D DIM WAS .030 X 45° IS .03 X 45°, ADDED DATUM A AND GD&T FEATURE CONTROL FRAME. **-5** CH'D DIM WAS .030 X 45° IS 2X .03 X 45°. | 1/11/2017 | RJC | JAG |




| ASSY QTY | ASSY QTY | B/O | Part # | UNIT QTY | Description | Material | B/O INFORMATION OR SPECIFICATIONS | PG. |
|---|---|---|---|---|---|---|---|---|
| | | | -1 | 1 | TRUNNION CENTERING SHAFT | 4140/4142 | | 2 |
| | | | -4 | 1 | TRUNNION INNER RACE REMOVAL PLUG | 4140/4142 | | 3 |
| | | | -5 | 1 | TRUNNION BEARING RACE PLUG | 4140/4142 | | 4 |
| | | B/O | -6 | 1 | BOLT | STEEL | AN5-4A | 1 |
| | | B/O | -7 | 1 | WASHER | STEEL | AN970-5 | 1 |

DART AEROSPACE

TITLE
# T/R TRUNNION CENTERING TOOLS

DWG NO. RBT18517 REV 2

MAT'L
HEAT TREAT
FINISH
SPEC

DRAWN BY: COLE
CHECKED: DUERFELDT
OPPS APPR: ANDERSON
QA APPR: LINDSAY
APPROVED: GILBERT

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .005 FRACTIONS ± 1/8
.XX ± .01 ANGLES ±.5°
.X ± .1 SURFACES = 125 √

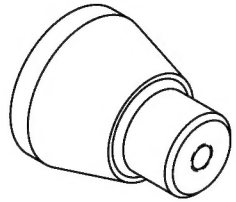
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009

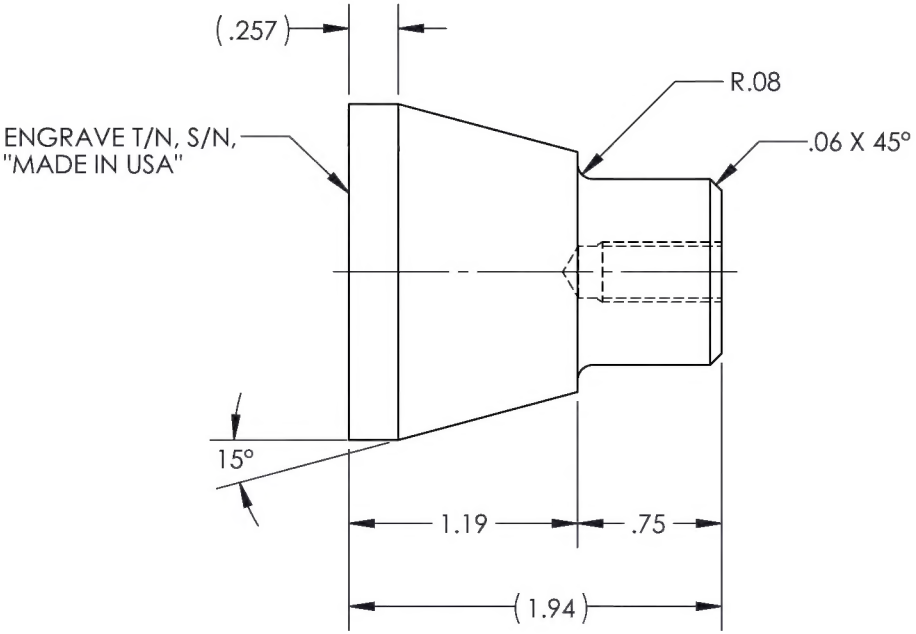
USED ON MODEL
BELL 206A & B

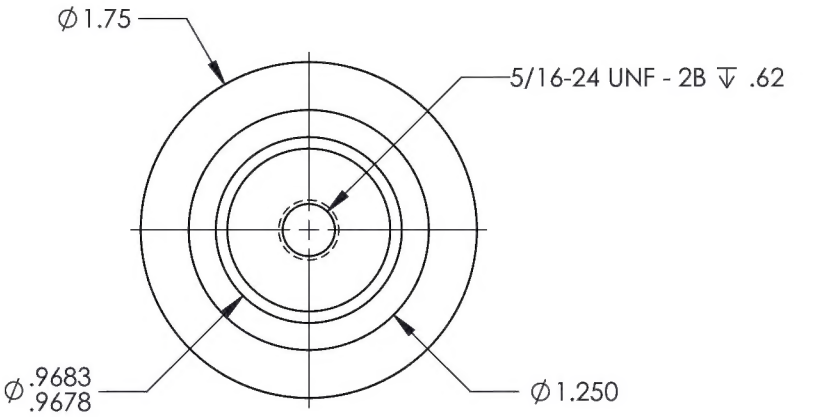
SCALE 1:2 DATE 4/25/2003 SHEET 1 OF 4

REVISIONS

| REV | ECR | DESCRIPTION | DATE | INITIAL | APPROVED |
|---|---|---|---|---|---|
| 2 | 16-0278 | **-1** CH'D DIM WAS R.080 IS R.08, WAS .060 X 45° IS .06 X 45°, WAS 5/16-24 UNF DEPTH .625 IS 5/16 -24 UNF -2B ↧ .62, CH'D MATERIAL WAS 4140 IS 4140/4142, ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D, CH'D ENGRAVE NOT WAS ENGRAVE P/N IS ENGRAVE T/N, S/N, "MADE IN USA", DELETED WORK INSTRUCTIONS. | 1/11/2017 | RJC | JAG |






-1

TRUNNION CENTERING SHAFT

DART AEROSPACE

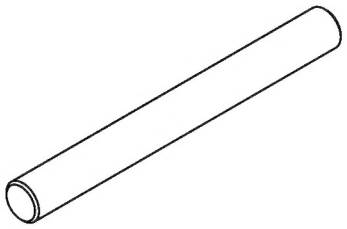
TITLE

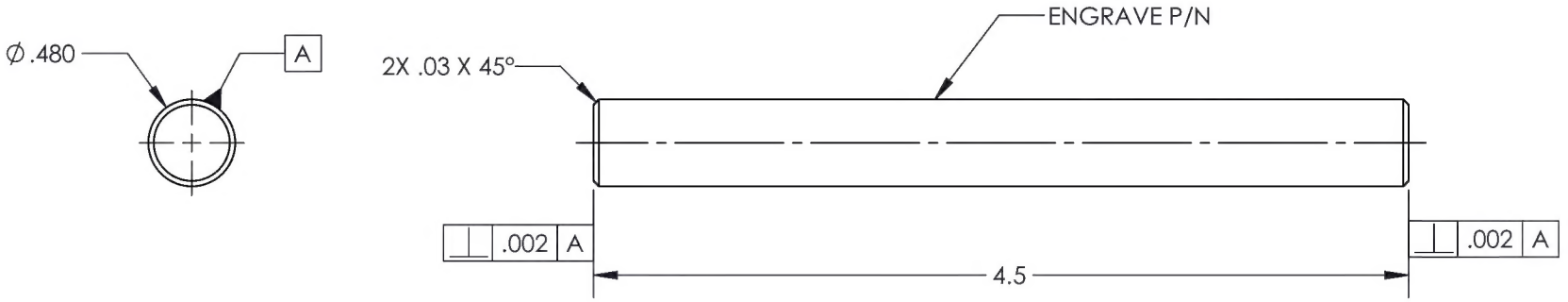
# T/R TRUNNION CENTERING TOOLS

| | | | |
|---|---|---|---|
| DWG NO. | RBT18517-1 | | REV 2 |
| MAT'L 4140/4142 | | UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES<br>.XXX ± .005 FRACTIONS ± 1/8<br>.XX ± .01 ANGLES ±.5°<br>.X ± .1 SURFACES = 125 √<br>1. BREAK ALL SHARP EDGES .015 x 45° OR .015R<br>2. DIMENSIONAL LIMITS APPLY AFTER PLATING<br>3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 | |
| HEAT TREAT | | | |
| FINISH BLACK OXIDE | | | |
| SPEC QMSI-6.2.2, B.O. REV D | | | |
| DRAWN BY: | COLE | | |
| CHECKED: | DUERFELDT | | |
| OPPS APPR: | ANDERSON | | |
| QA APPR: | LINDSAY | USED ON MODEL | |
| APPROVED: | GILBERT | BELL 206A & B | |
| SCALE 1:1 | DATE 4/25/2003 | SHEET 2 OF 4 | |

REVISIONS

| REV | ECR | DESCRIPTION | DATE | INITIAL | APPROVED |
|---|---|---|---|---|---|
| 2 | 16-0278 | **-4** CH'D DIM WAS .030 X 45° IS .03 X 45°, CH'D MATERIAL WAS 4140 IS 4140/4142, ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D, DELETED WORK INSTRUCTIONS. ADDED DATUM A AND GD&T FEATURE CONTROL FRAME. | 1/11/2017 | RJC | JAG |






-4

TRUNNION INNER RACE REMOVAL PLUG

DART AEROSPACE

TITLE
# T/R TRUNNION CENTERING TOOLS

| | |
|---|---|
| DWG NO. | RBT18517-4 |
| REV | 2 |
| MAT'L | 4140/4142 |
| HEAT TREAT | |
| FINISH | BLACK OXIDE |
| SPEC | QMSI-6.2.2, B.O. REV D |
| DRAWN BY: | COLE |
| CHECKED: | DUERFELDT |
| OPPS APPR: | ANDERSON |
| QA APPR: | LINDSAY |
| APPROVED: | GILBERT |
| SCALE | 1:1 |
| DATE | 4/25/2003 |
| SHEET | 3 OF 4 |

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .005 FRACTIONS ± 1/8
.XX ± .01 ANGLES ±.5°
.X ± .1 SURFACES = 125

1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009

USED ON MODEL
BELL 206A & B

| REVISIONS | | | | | |
|---|---|---|---|---|---|
| REV | ECR | DESCRIPTION | DATE | INITIAL | APPROVED |
| 2 | 16-0278 | **-5** CH'D DIM WAS .030 X 45° IS 2X .03 X 45°, CH'D MATERIAL WAS 4140 IS 4140/4142, ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D, DELETED WORK INSTRUCTIONS. | 1/11/2017 | RJC | JAG |


-5

TRUNNION BEARING RACE PLUG

DART AEROSPACE

TITLE
# T/R TRUNNION CENTERING TOOLS

| DWG NO. | REV |
|---|---|
| RBT18517-5 | 2 |

| | |
|---|---|
| MAT'L | 4140/4142 |
| HEAT TREAT | |
| FINISH | BLACK OXIDE |
| SPEC | QMSI-6.2.2, B.O. REV D |
| DRAWN BY: | COLE |
| CHECKED: | DUERFELDT |
| OPPS APPR: | ANDERSON |
| QA APPR: | LINDSAY |
| APPROVED: | GILBERT |

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .005 FRACTIONS ± 1/8
.XX ± .01 ANGLES ±.5°
.X ± .1 SURFACES = 125

1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009

USED ON MODEL
BELL 206A & B

| SCALE | DATE | SHEET |
|---|---|---|
| 2:1 | 4/25/2003 | SHEET 4 OF 4 |